

Date: Tuesday, 28/04/2009 2:22:12 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-UTILITY BASKET RH  
 Job Number : 47572  
 Estimate Number : 12433  
 P.O. Number :  
 This Issue : 28/04/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LARGE FAB ASSY  
 Previous Run : 41327  
 Part Number : D205541044  
 Drawing Number : IIN D205-541 REV G  
 Project Number :  
 Drawing Revision : G  
 Material : SHIP  
 Due Date : 05/05/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09.04.28  
 Comment : Est Rev:C Re-Format 02-08-30 KJ  
 Est Rev:D chg to revG Ecn 1157 08-03-19 DD verified by:

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: Photocopy bluefile &amp; type labels per PPPD205-541-044

CHG002



2.0	47572A	350/212/130 BASKET LID
-----	--------	------------------------



Comment: Sub-Component 350/212/130 BASKET LID

1 x D2512 Batch B 47572A



3.0	47572B	212 BASKET BASE ASS'Y RH
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Comment: Sub-Component 212 BASKET BASE ASS'Y RH

1 x D3053-042 Batch B 47572B



4.0	D2022101	Spacer
-----	----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spacer

Batch: B 41928



5.0	D2258300	Label
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Placard

Batch: B 42011



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Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2332041	Lid Prop Assembly 6.69" long
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Lid Prop Assembly 6.69"  
Batch: B45682

7.0	D2530	Handle Weldment
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Handle Weldment  
Batch: 45683

8.0	D2535	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spring  
Batch: B45389

9.0	D2537	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing  
Batch: B45662

10.0	D2931	Bumper
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bumper  
Batch: 21139

11.0	AN316A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M109798

12.0	AN47A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
Batch: M110155

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

M107715

SS 09105/19 (X)

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

M108255

SS 09105/19 (X)

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: \_\_\_\_\_

M110625

SS 09105/19 (X)

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

M110363

SS 09105/19 (X)

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

M110363 M110153

SS 09105/19 (X)

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: \_\_\_\_\_

M110523

SS 09105/19 (X)

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: \_\_\_\_\_

M110382

SS 09105/19 (X)

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Job Number: 47572

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M 111724

SS 09105/19 (X)

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M 110844

SS 09105/19 (X)

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 110450

SS 09105/19 (X)

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 109840

SS 09105/19 (X)

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M 106375

SS 09105/19 (X)

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg.

SS 09-05-20 (X)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09105/20 (X)

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Job Number: 47572

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

28.0	D21991	Strut Details
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Struts, 19"  
Batch: B38453

29.0	D219923	Strut Details
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B401A5

30.0	D219925	Strut Details
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut  
Batch: B42594

31.0	D2498	Mounting Bracket, 205 Basket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Mounting Bracket  
Batch: B37542

32.0	D2499	Mounting Bracket, 205 Basket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Mounting Bracket  
Batch: B37543

33.0	D2515	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing  
Batch: 29138

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Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Lug

Batch: 40200

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M110155

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bolt

Batch: M169754

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Bolt

Batch: M111477

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107534

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M110625

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M110363

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Job Number: 47572

Part Number: D205541044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	AN960JD416	Washer
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Comment: Qty.: 29.0000 Each(s)/Unit Total: 29.0000 Each(s)  
Washer

M110303

SS 09/05/19 (X)

42.0	AN960JD516	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)  
Washer  
Batch: M110523

SS 09/05/19 (X)

43.0	MS21042L4	Nut
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)  
Nut  
Batch: M110450

SS 09/05/19 (X)

44.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Nut  
Batch: M109840

SS 09/05/19 (X)

45.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/05/20 (X)

46.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D205-541-044

Location: P  
PPP Rev: 9/6/20

(10)

30

47.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20  
MF

Job Completion



MF  
09-05-20

## 5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
X				D205-541-043	HELI-UTILITY-BASKET, LH
	X			D205-541-044	HELI-UTILITY-BASKET, RH
		X		D205-541-045	HELI-UTILITY-BASKET, LH
			X	D205-541-046	HELI-UTILITY-BASKET, RH
2*	2*			D2022-101	SPACER
1	1	1	1	D2199-1	STRUT
1	1	1	1	D2199-23	STRUT
1	1	1	1	D2199-25	STRUT
1*	1*	1*	1*	D2258-300	LABEL
1*	1*	1*	1*	D2332-041	PROP ASSEMBLY
1	1	1	1	D2498	MOUNTING LUG
1	1	1	1	D2499	MOUNTING LUG
1*	1*			D2512	BASKET LID ASSEMBLY
2	2	2	2	D2515	BUSHING
1*	1*	1*	1*	D2530	HANDLE ASSEMBLY
2*	2*	2*	2*	D2535	SPRING
2*	2*	2*	2*	D2537	BUSHING
2*	2*			D2931	BUMPER
1	1	1	1	D3052-1	MOUNTING LUG
1*				D3053-041	BASKET BASE ASSEMBLY, LH
	1*			D3053-042	BASKET BASE ASSEMBLY, RH
		1*		D3712-041	BASKET BASE
			1*	D3712-042	BASKET BASE
		1*		D3713-041	LID ASSEMBLY
			1*	D3713-042	LID ASSEMBLY
		6*	6*	D3723-1	BUSHING
2*	2*	2*	2*	AN3-16A	BOLT
2*	2*			AN4-7A	BOLT
2	2	2	2	AN4-7A	BOLT
3	3	3	3	AN4-12A	BOLT
9	9	9	9	AN4-13A	BOLT
2	2	2	2	AN4-14A	BOLT
		3*	3*	AN4-20A	BOLT
1*	1*	1*	1*	AN4-22A	BOLT
1*	1*	1*	1*	AN4-24A	BOLT
1	1	1	1	AN5-7A	BOLT
1	1	1	1	AN5-13A	BOLT
4*	4*	4*	4*	AN5-17A	BOLT
2*	2*	6*	6*	AN960JD416	WASHER
27	27	27	27	AN960JD416	WASHER
2*	2*	2*	2*	AN960JD416L	WASHER
4*	4*	4*	4*	AN960JD516	WASHER
3	3	3	3	AN960JD516	WASHER
2	2			AN960JD8	WASHER
4*	4*	4*	4*	AN970-4	WASHER

...CONTINUED ON NEXT PAGE

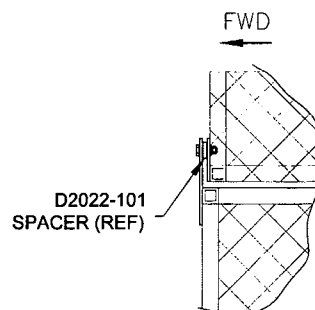
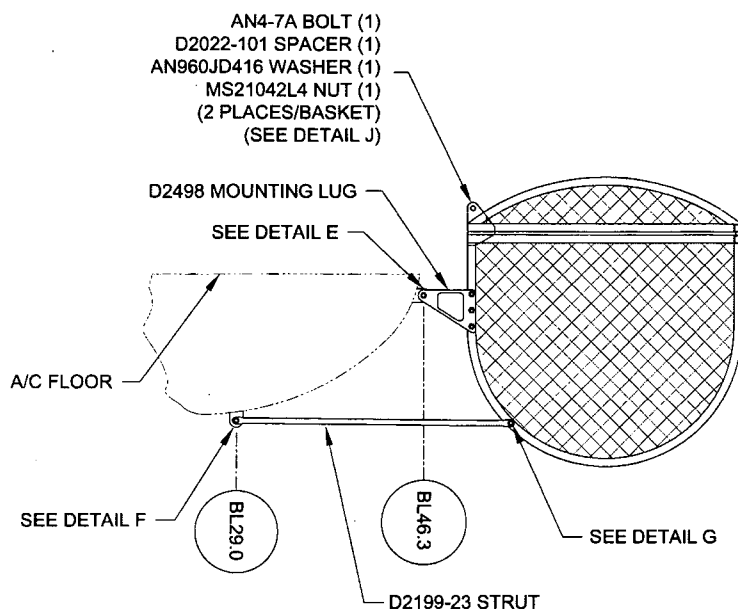
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Date: 08.03.04  
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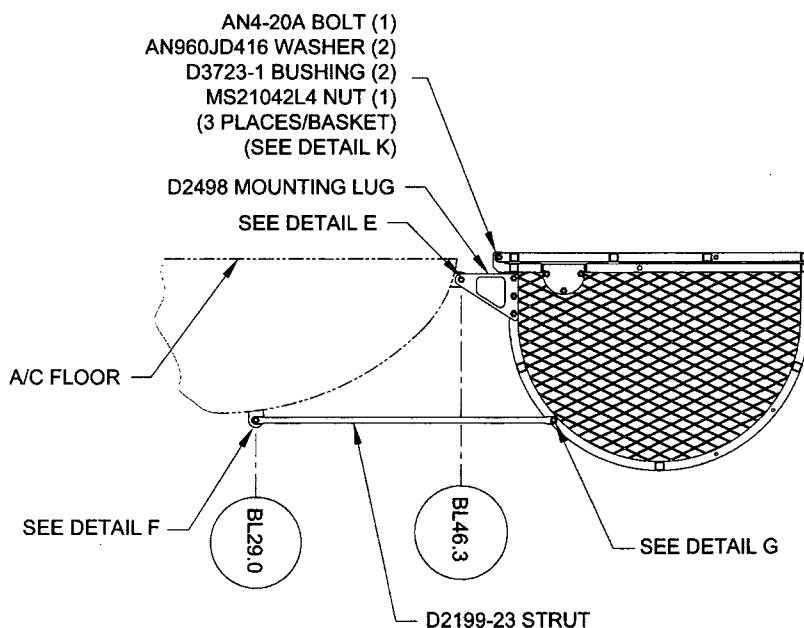




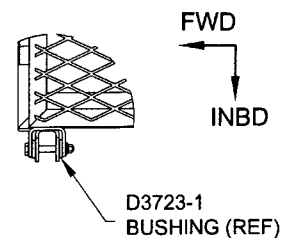
DETAIL J  
HINGE DETAIL:  
SIDE VIEW, LOOKING OUTBOARD.  
OTHER END OPPOSITE

**Figure 2a - Section A-A Looking Fwd at STA 84.29**

(D205-541-044 Shown; D205-541-043 Opposite)

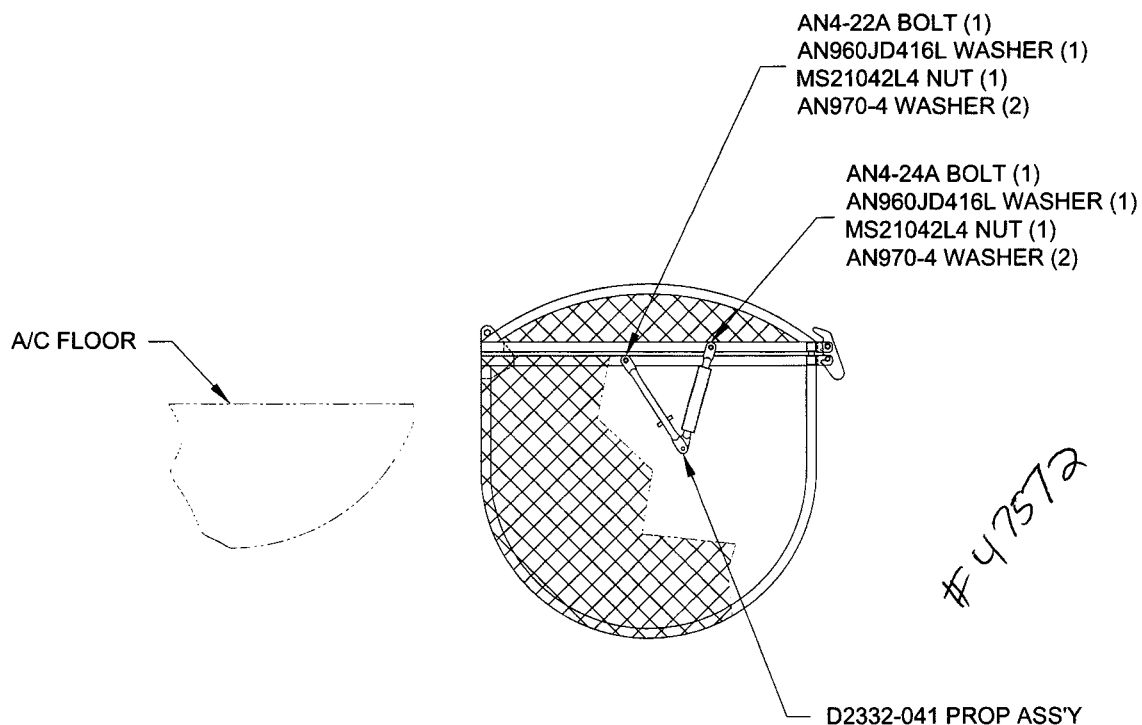


DETAIL K  
HINGE DETAIL:



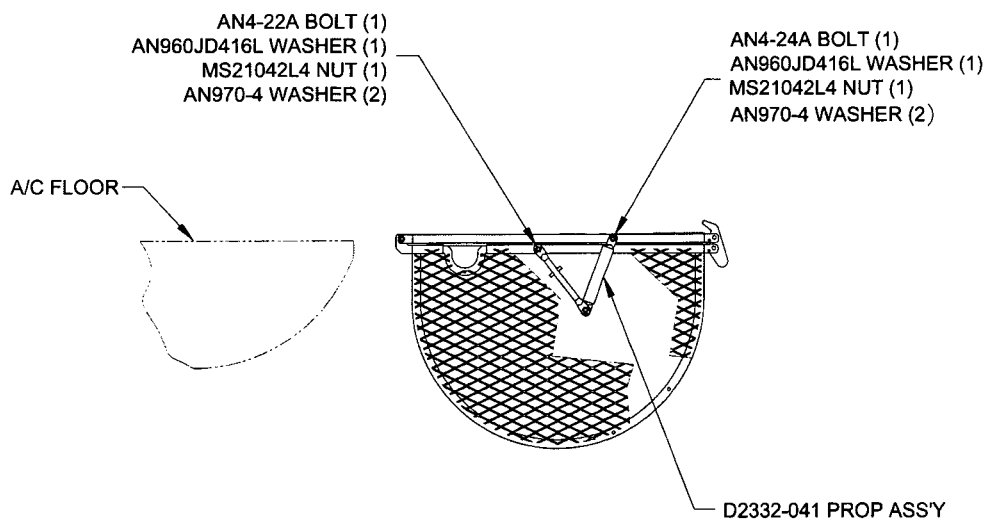
**Figure 2b - Section A-A Looking Fwd at STA 84.29**

(D205-541-046 Shown; D205-541-045 Opposite)



**Figure 5a – Section D-D Looking Fwd at STA 180.08**

(D205-541-044 Shown; D205-541-043 Opposite)



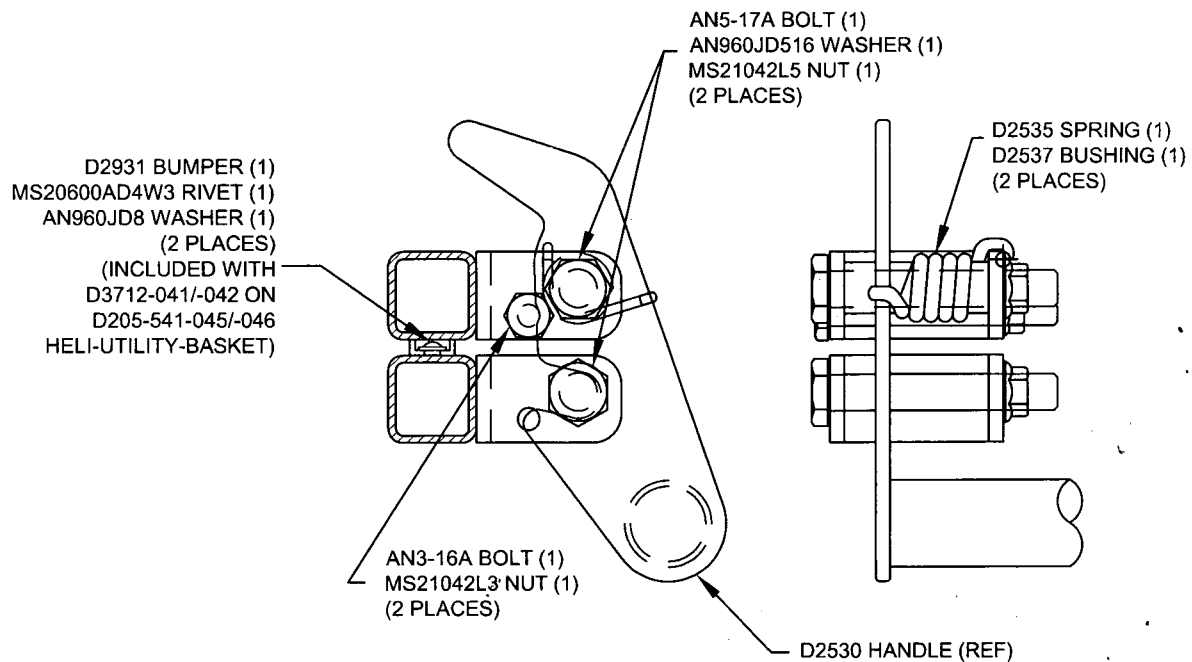
**Figure 5b – Section D-D Looking Fwd at STA 180.08**

(D205-541-046 Shown; D205-541-045 Opposite)

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**Figure 25-9 – Detail 'H' Handle Assembly**

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